









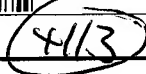






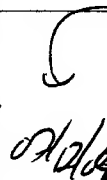

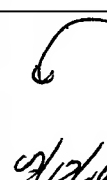
Date: Friday, 10/5/2007 10:58:54 AM
 *User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 35037	
Estimate Number : 10584	
P.O. Number : <i>N/A</i>	Part Number : D1048
This Issue : 10/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 30373	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/12/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>100</i> Um: Each
Comment : Est: B 02.02.22 Re-format NG Est Rev: C Now on Waterjet 06-12-06 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304S16GA 304/316 .063 Sheet
	 <i>1.3224</i> 
Comment: Qty.: 0.0116 sf(s)/Unit Total : 0.5775 sf(s) 304/316 .063 Sheet <i>B 07-10-16</i> Batch: <i>105130</i>	
2.0	WATER JET FLOW WATER JET
	 
Comment: FLOW WATER JET 1-Cut as per Dwg D1048 Dwg Rev: <i>A</i> <i>B 07-10-16</i>  Prog Rev: <i>A</i> 2-Deburr if necessary	
3.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	 <i>AB 07-10-16</i> 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8 SECOND CHECK
	  <i>can't</i>
Comment: SECOND CHECK <i>Er 07/10/16</i> 	
5.0	SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if required. Break all sharp corners .010 / .020 as per dwg. <i>SAD 07/10/22</i> 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/12/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-12-03	6.0	Scrap one part, testing was unclear. Part was formed wrong R.C. Hemman error	 08/10/02	Scrap & destroy	SAN 07-12-03	 07/12/04	 08/10/02	 07/12/04

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 10:58:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 35037

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



112
P/O
Murray Day

Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

SAD 07-12-07

112

7.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

2 7/12/04 x112

8.0

POWDER COATING

POWDER COATING



M100700

112X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L 07/12/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



112

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-12-05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2

7/12/06 SD 112X

11.0

QC21

FINAL INSPECTION/W/O RELEASE



112

Comment: FINAL INSPECTION/W/O RELEASE

07/12/06

Job Completion



U 07.12.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 BCL

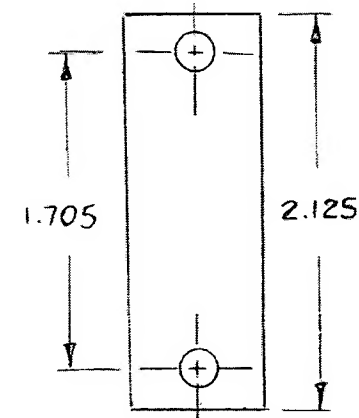
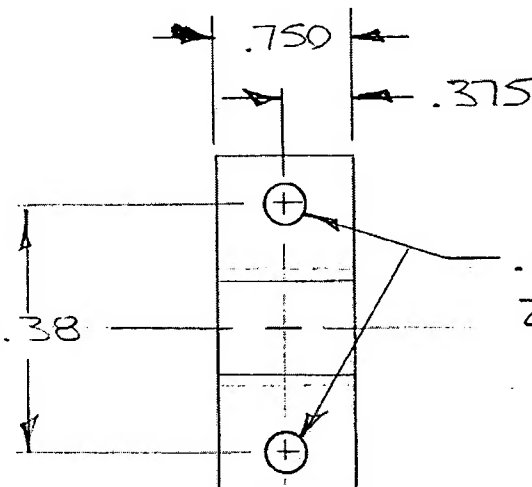
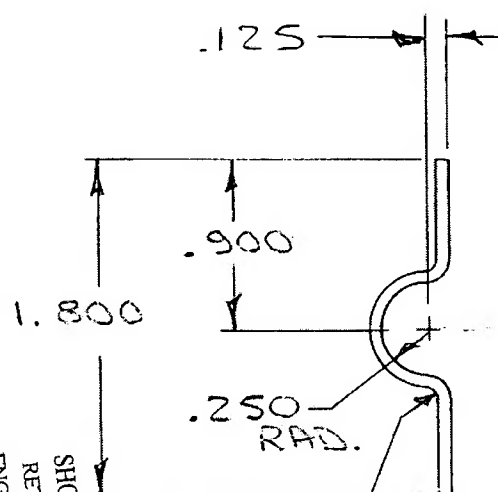
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35037



A		REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
RF		DRAWN			BASIC CODE		CONTRACT NO.		DATE		DART AERO ACCESSORIES INC. VANCOUVER CANADA	
		APPROVED			D=ORANGE DIGIT/NO OF SHEETS C=COUNTERSINK		DIA. DASH NO. H=HEAD NEAR SIDE F=HEAD FAR SIDE		DRAWN BRADLEY			
					LENGTH DASH NO. W=SPOTWELD				DESIGN BRADLEY			
					BASIC CODES				STRESS		TITLE CLAMP	
					B2=MS20470AD B6=MS20426AD				CHECKED		CODE	
									CURRENT		DWG NO. D1048	
											REV A	
											SCALE 1:1 SHT 1 OF 1	

REPORT ALL DISCREPANCIES — DO NOT SCALE

D1048

